

Date: Monday, 1/22/2007 7:42:21 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIGHT ARM WELDMENT
<b>Job Number</b> : 30366	
<b>Estimate Number</b> : 12279	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3354041
<b>This Issue</b> : 1/22/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3354 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 29890	<b>Material</b> : N/A
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 1/29/2007 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : est rev . A 06.02.09 new issuey EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D33549	handle socket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-9	Handle socket	B29905

B29905

CPL 07.01.22

(5)

2.0	D33541	inner shaft
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-1	Inner shaft	B30109

B30109

CPL 07.01.22

(5)

3.0	D33547	left arm plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-7	Left arm plate	B29904

B29904

CPL 07.01.22

(5)

4.0	D33543	shaft
-----	--------	-------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-3	Shaft	B29902-1

B29902-1

CPL 07.01.22

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:42:22 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 30366

Part Number: D3354041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

TP-134 TENSION PIN

Batch: M16362

PLC 07.01.22

(5)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

PLC 07.01.22

(5)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/01/22 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/22 (5)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M18052

SL/yl 07/01/22.

(5)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22 (5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

SH63 07/01/22 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:42:22 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 30366

Part Number: D3354041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



5

Comment: FINAL INSPECTION/W/O RELEASE

PO 7/01/24

Job Completion



U Brol. 24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

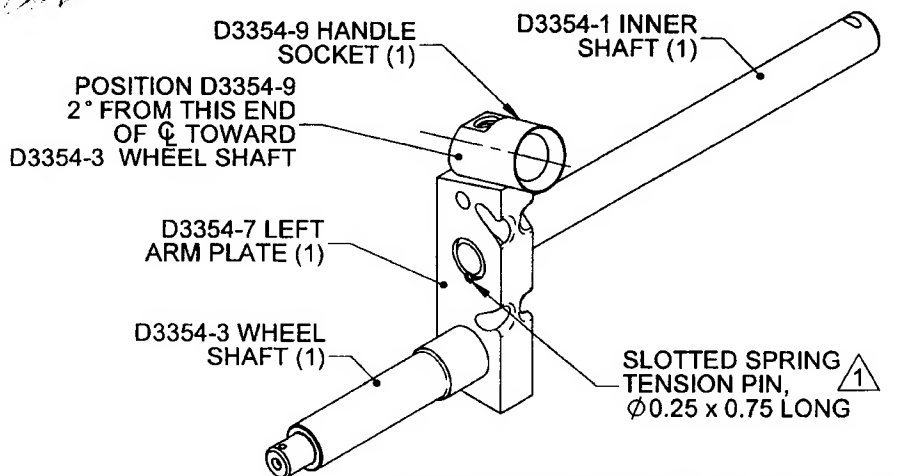
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

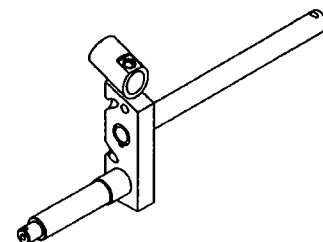


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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:4
A	04.12.13	NEW ISSUE	

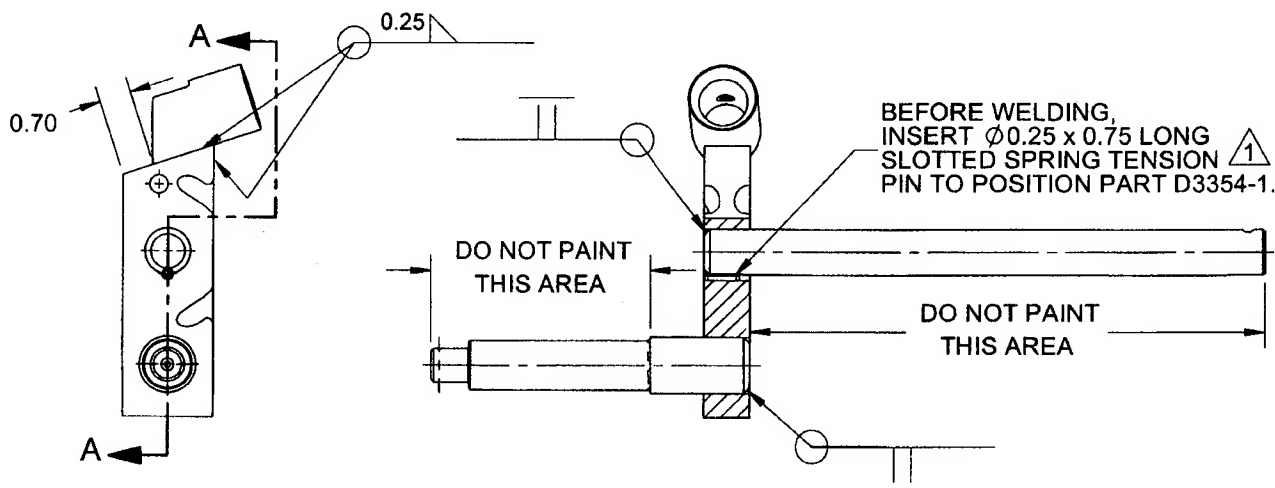
RELEASED  
86/03/07



**D3354-041 LEFT ARM WELDMENT**



**D3354-042 MIRROR ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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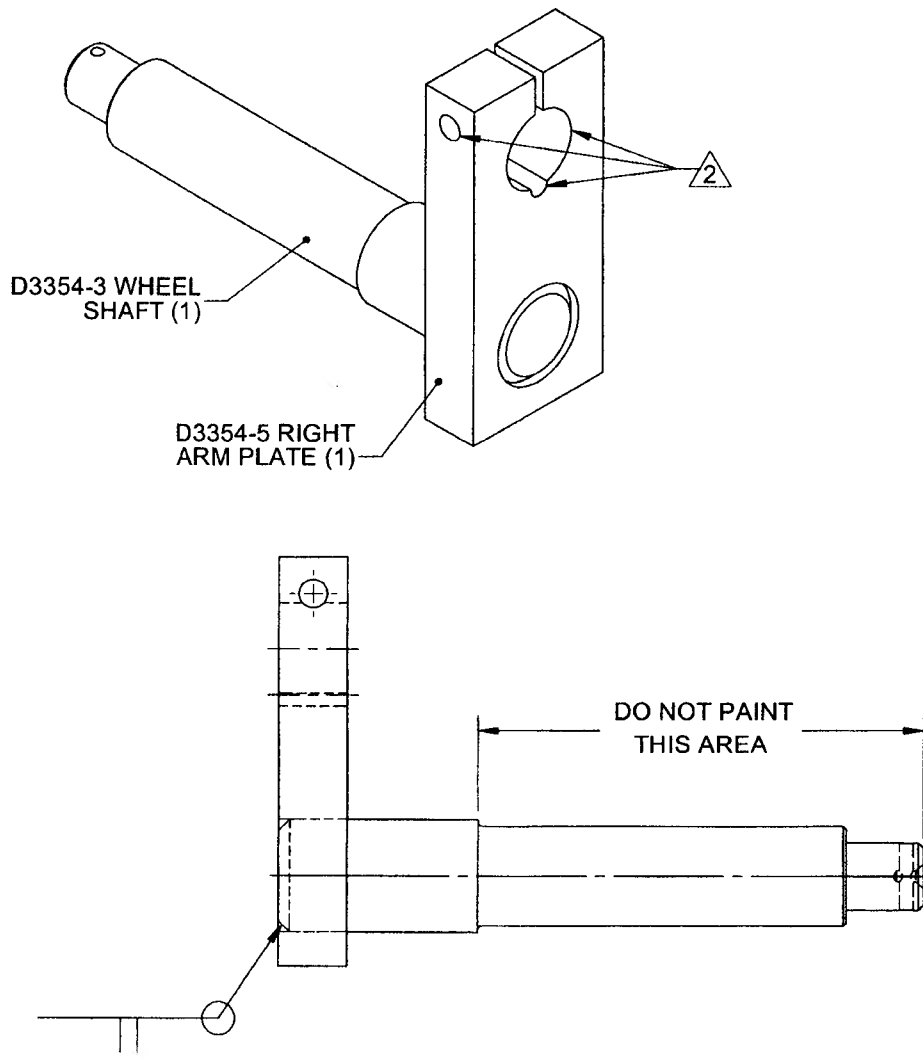
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

RELEASED  
06/03/19



### D3354-043 RIGHT ARM WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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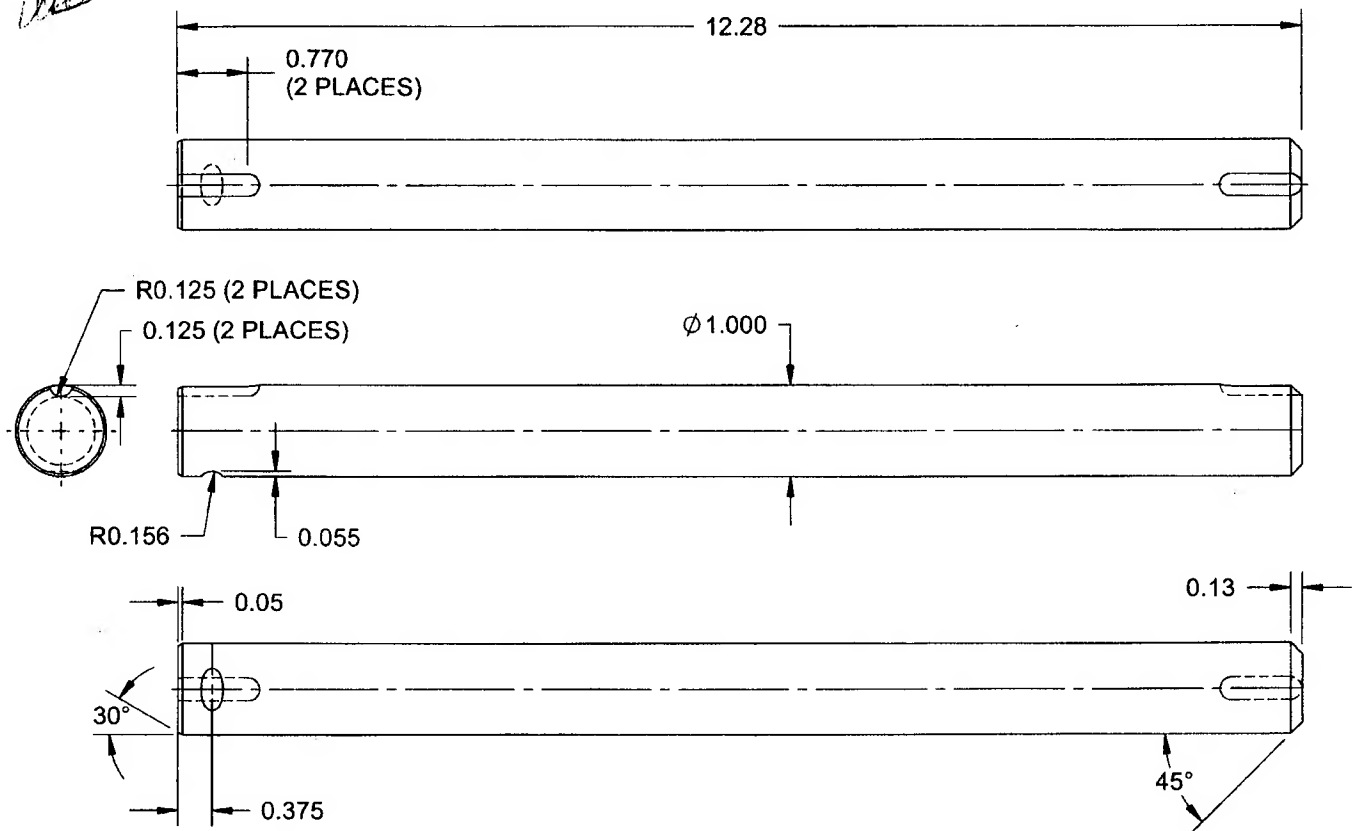
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C207101122  
w/o 30364



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DATE <b>04.12.13</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

**RELEASED**  
06/23/01**D3354-1 INNER SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

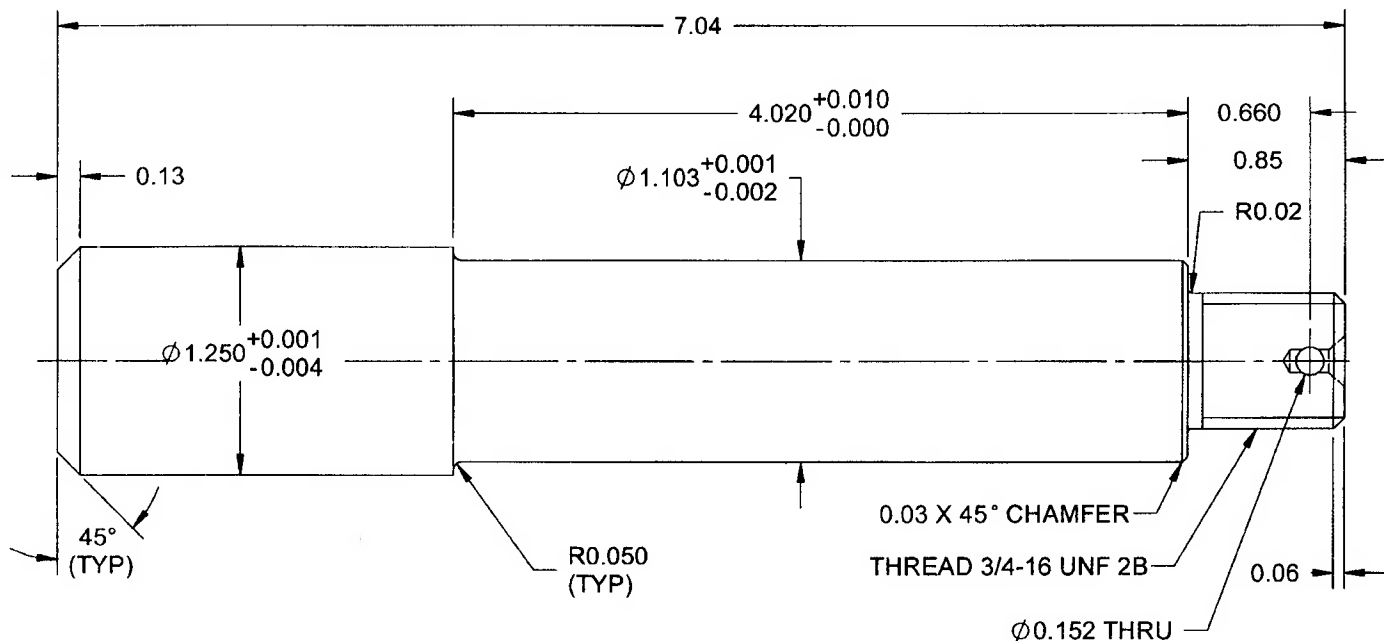
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ap 30346

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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*[Handwritten: 06/03/14]***D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi$  1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

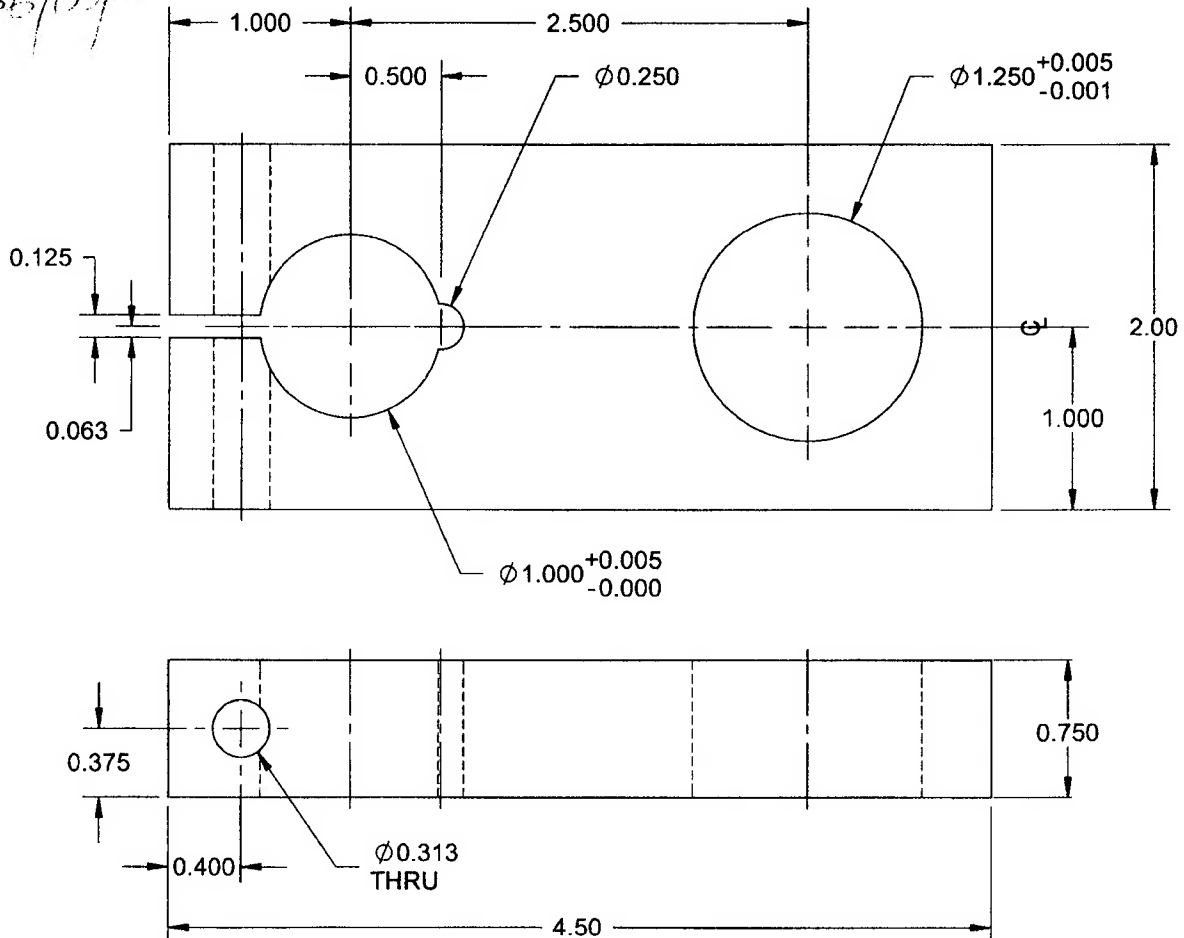
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*CL07101122*  
*w/o 30366*

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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*06/03/14***D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

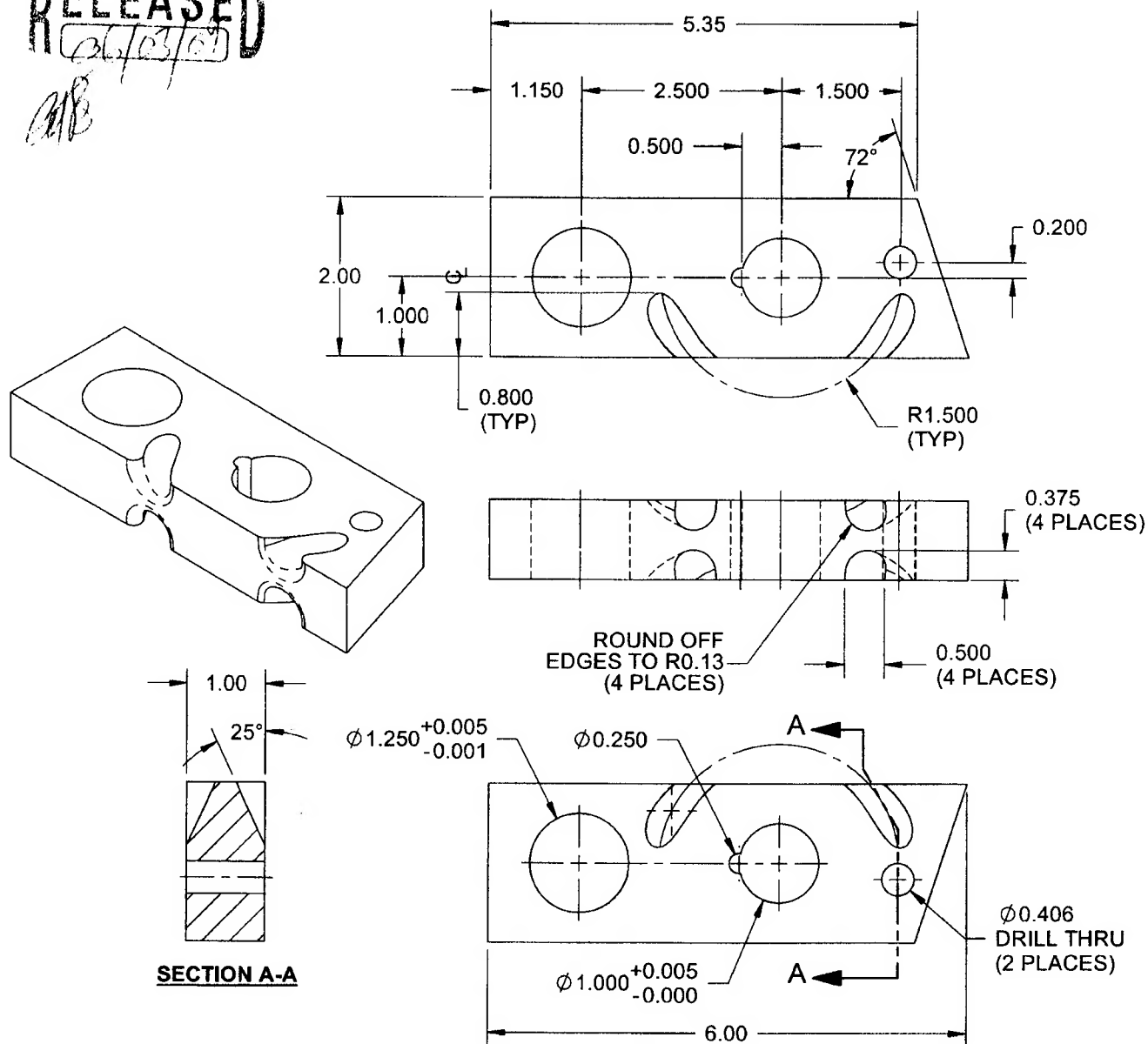
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*CL 07/01/22  
w/0 30346*

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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
*06/03/08*  
*ME***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

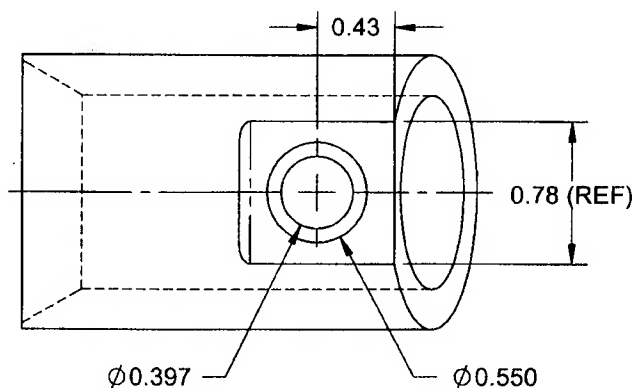
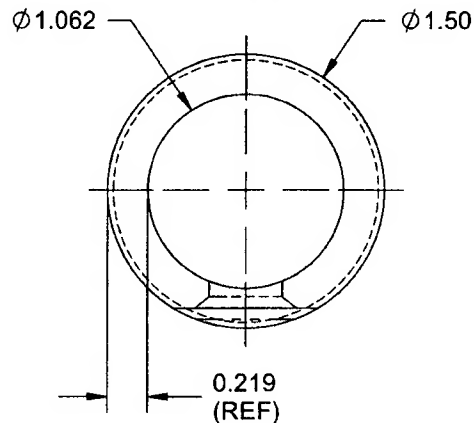
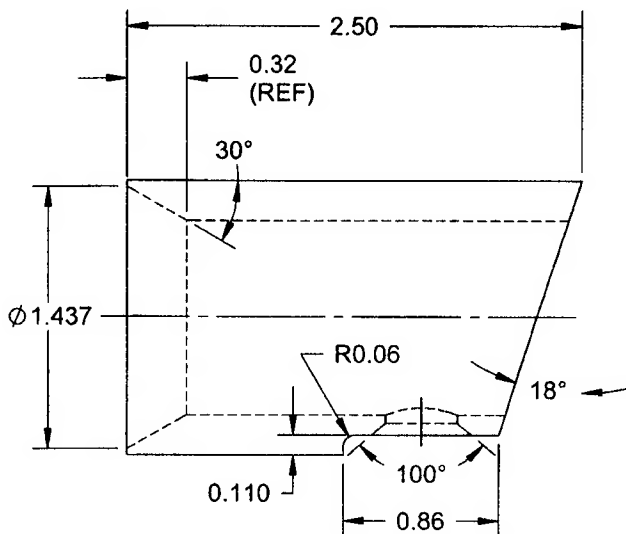
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*07/01/22*  
*W10 30266*



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DATE <b>04.12.13</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1



### **D3354-9 HANDLE SOCKET**

#### **NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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*C207101/22*  
*w/o 30366*